

Date: Wednesday, 17/12/2008 10:48:44 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> :	D3630-041 - REWORK
<b>Job Number</b> :	44144		
<b>Estimate Number</b> :	10804		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3630041
<b>This Issue</b> :	17/12/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	NCR08-122
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
<b>Previous Run</b> :	44113	<b>Drawing Revision</b> :	
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	24/12/2008
<b>Written By</b> :		<b>Qty:</b>	3
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :			

## Additional Product

Job Number:



*Leaf*

<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D3630041	Cyclic Stick
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Cyclic Stick

Remove from stock:

Qty: 3 B 37120Qty:      B     Qty:      B     

2.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP  
 Ensure all dimensions are as per the drawing.

*PTU* Last page.

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 Fill the affected 0.189" holes with weld on the D3630-1  
 Grind flush, and ensure there is no weld on the inside wall of the tubing.

4.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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**Comment:** VISUAL INSPECTION OF GROUND WELDS


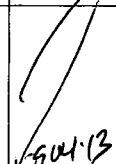

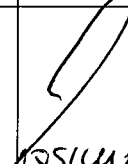
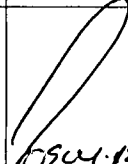
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Drill the 0.189" hole as per dwg on the D3630-1.  
 Debur inside and out.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3630-041 PAR #: NIA Fault Category: Third Party Design NCR: (Yes) No DQA: D Date: 09/04/15  
 Resolution: NIA Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/04/15

NCR: <u>44144</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-13	2.0	Scrap all parts. Holes are not to dwg. Form: length are not as per template.  R.C: lack of attention to dwg.	 09/04/13	Scrap: no replace.	 09/04/13	 09/04/13	 09/04/13	 09/04/13

NOTE: Date & initial all entries

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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3630-041 - REWORK

Job Number: 44144

Part Number: D3630041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure all other dimensions are as per the drawing.

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify the parts with the new batch # and return to stock.

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE

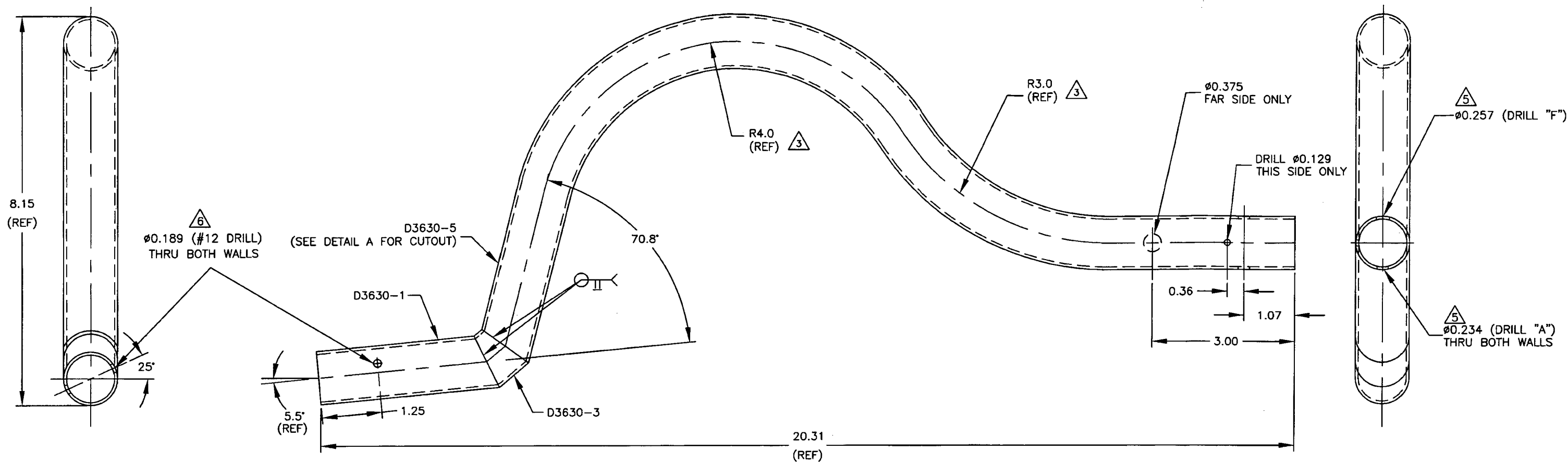


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*W Gray*



### D3630-041 CYCLIC STICK

(REPLACES GENEVA P/N G10202)

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING 1.125" OD X 0.065" WALL (REF. DART SPEC M304TR1.125W.065)
- 2) FINISH: NONE
- 3) REFER TO TEMPLATE DT8940
- 4) WELD PER DART QSI 004
- 5) DRILL  $\phi 0.234$  THRU BOTH WALLS THEN DRILL  $\phi 0.257$  THRU ONE WALL AS SHOWN
- 6) DRILL  $\phi 0.189$  THRU BOTH WALLS AT 25° OFF HORIZONTAL AXIS AS SHOWN
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 10) IDENTIFY WITH DART P/N "D3630-041" USING FINE POINT PERMANENT INK MARKER

#### PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041	D3630-041	CYCLIC STICK
1	D3630-1	TUBE
1	D3630-3	TUBE
1	D3630-5	TUBE

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 44144

**D3630-1**  
(REPLACES GENEVA P/N G10202-1)

**D3630-3**  
(REPLACES GENEVA P/N G10202-2)

**D3630-5**  
(REPLACES GENEVA P/N G10202-3)

DETAIL A: CUTOUT

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A	07.05.11	NEW ISSUE: REPLACES G10202
DESIGN CLB	DRAWN BY JC	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED B	APPROVED JH	DRAWING NO. D3630
DATE 07.05.11	TITLE CYCLIC STICK	REV. A SHEET 1 OF 1 SCALE 1:2